

## Standard machine specifications

		QUICK TURN PRIMOS 100 S
Capacity	Universal	200 U
	Max. swing	ø444 mm (ø17.48")
	Max. machining diameter	ø180 mm (ø7.09")
	Max. machining length	200 mm (7.87")
	Bar work capacity	ø36 mm (ø1.42")
Travel	X axis	110 mm (4.33")
	Z axis	240 mm (9.45")
Spindle	Chuck size	6"
	Spindle speed	5000 rpm
	Number of spindle speed ranges	1-Stepless
	Spindle nose	ø140 mm (ø5.51")
	Spindle bore	ø45 mm (ø1.77")
Turret	Turret type	8 position drum turret
	Number of tools	8 tools
	Tool shank height	20 mm (0.75")
	Boring bar shank diameter	25 mm (1")
	Turret indexing time	0.2 sec
Feed rate	Rapid traverse rate: X axis	30 m/min (1181 ipm)
	Rapid traverse rate: Z axis	30 m/min (1181 ipm)
Tailstock (OP)	Positioning	Manual
	Tailstock center	MT-No.3 (Dead center)
Motors	Spindle motor (40% ED/Cont. rating)	9/7.5 kW (12/10 HP)
	Coolant pump motor	0.25kW (0.34HP) [0.52kW (0.94HP) (option)]
Power requirement	Required power capacity (Cont. rating)	17.15 kVA
Coolant	Tank capacity	130 L (34 gallons)
Machine size	Machine height	1700mm (66.93")
	Floor space requirement	1395 mm × 1230 mm (54.92" × 48.43")
	Weight	2000 kg (4400 lb.)
Noise	Equivalent continuous sound pressure level at operator position (dependent on equipment options)	Less than 80 dB (A)

## MAZATROL Smart Specifications



	MAZATROL	EIA/ISO
Number of controlled axes	Max. 2 axes (simultaneous 2 axes)	Max. 2 axes (simultaneous 2 axes)
Least input increment	0,0001mm, 0,00001 inch, 0,0001°	
Max. programmable value	±99999,9999 mm, ±9999,99999 inch, ±99999,9999°	
High precision control	Smooth high gain control, Absolute position detection	
Interpolation	Positioning (Independent axes control), Linear interpolation	
	—	Thread cutting (equal pitch, variable pitch)
Feed function	Rapid traverse, Cutting feed (per revolution, per minute), Feed rate clamp, Override (Rapid traverse, Cutting feed, External override, 2nd override, Override cancel)	
	Automatic acceleration/deceleration feed rate (Linear acc./dec., time constant), Constant tangential speed control, Dry run	
Program registration	256, 512	
Program storage capacity	320 KB	
Display	10.4 inch color TFT	
NC display languages	English, German, French, Italian, Spanish, Dutch, Norwegian, Swedish, Finnish, Danish, Portuguese, Turkish, Polish, Czech, Romanian	
	Chinese simplified form, Chinese traditional form, Korean, Slovakian, Russian, Hungarian, Bulgarian, Japanese, (one touch language switching)	
Data input/output	USB	
Spindle function	S code output (8-digit binary output, Analog output, Actual revolution speed binary output), Constant surface speed	
	Spindle revolution control (RPM clamp, high speed indication/speed change detection, Rotary speed display), Spindle override (0 - 150%)	
Tool function	T code output (8-digit binary data, next tool, used tool), Tool life monitoring (Number of workpieces, time and wear compensation)	
	Spare tool exchange, Tool management (Group number, Pocket number)	
Tool compensation	Tool tip R compensation, Tool tip shape compensation, Tool position compensation, Tool wear compensation, Tool radius compensation	
Number of registered tools	Max. 64	
Tool offset pairs	128	
Miscellaneous functions	M code output (M3-digit), simultaneous output of four 3-digit M codes, Second miscellaneous functions (B 3-digit output), High speed MSTB interface	
Coordinate system control	MAZATROL coordinate system	Machine coordinate system (System shift, Zero point shift)
	—	Work coordinate system (System shift)
Manual operation	Rapid traverse, Cutting feed, Handle feed, Zero-point return, Manual control (machine lock, gear shift, barrier cancel)	
	Manual spindle control (spindle start, stop, reverse, jogging)	
Automatic operation	Memory operation, MDI operation, Cycle start, NC reset, Single block, Feed hold, Single process	
	Optional block skip, Optional stop, Machine lock, Barrier cancel Feed override, Spindle control, Dry run, Manual handle control, Tool path storage (TPS)	
Background function	During automatic operation (Programming, Data input/output, Tool path check)	
Machine compensation	Backlash compensation, Pitch error compensation, Rotational axis pitch error compensation, Thermal displacement compensation,	
Protection function	Emergency stop, Over travel, Barrier (stored stroke limit, tool barrier, chuck barrier, tail barrier)	
	Interlock (cutting start, axis interlock), Alarm	
Measuring function	Manual measurement (Tool set measurement, Z-offset measurement), Automatic measurement	
	(Work measurement, Z-offset measurement, Tool tip point measurement, External measurement)	

\*Option